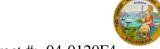
#### DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453 (707) 649-5493



Contract #: 04-0120F4

Cty: SF/ALA Rte: 80 PM: 13.2/13.9

File #: 69.28

# WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter **Report No:** WIR-017112 Address: 333 Burma Road **Date Inspected:** 12-Sep-2010

City: Oakland, CA 94607

**OSM Arrival Time:** 700 **Project Name:** SAS Superstructure **OSM Departure Time:** 1900 **Prime Contractor:** American Bridge/Fluor Enterprises, a JV

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

**CWI Name: CWI Present:** Yes No Gong Wai **Inspected CWI report:** Yes N/A **Rod Oven in Use:** Yes No No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No N/A **Qualified Welders:** Yes No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:** 

34-0006 **Bridge No: Component: OBG COMPONENT** 

### **Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side Yard

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG segment 12AW, weld No. SEG3004L-009. The welder is identified as #045270. ZPMC QC is identified as Mr. Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G(3F)-FCM-REPAIR-1. The repair report is identified as CWR1813. Bav#14

This QA Inspector observed the following work in progress:

SAW in the 1G position for the OBG segment 13AW, weld No. SEG3013AD-020. The welder is identified as #045270. ZPMC QC is identified as Mr.Xin Chen Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2221-B-L2c-S-2.

Visual Inspection after Blast at 11BW

This Quality Assurance (QA) Inspector performed random visual inspection of OBG segment 11BW internal bottom panel and side panel surfaces after grit blasting in between panel point PP98 to PP100. Areas that marked

## WELDING INSPECTION REPORT

(Continued Page 2 of 3)

for repair were recorded for future repair. Areas requiring additional grinding were marked by QA and repaired by ZPMC personnel.

Ultrasonic Testing (A,B,C and D-Scan )

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as splice joint joining between deck plate to deck Plate for segment 10AW to 10BW. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation are as follows

OBW10-003,004

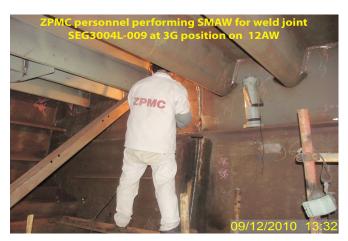
This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between side plate to edge Plate for segment 10AW and 10BW. This Inspection was performed after ABF UT Inspectors performed UT of this joint. The result was recorded onto a data sheet according to rejection criteria of "D" Scan procedure that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation are as follows

SEG059A-029 CA074-005

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.





# WELDING INSPECTION REPORT

(Continued Page 3 of 3)

## **Summary of Conversations:**

No relevant conversations

#### **Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
Reviewed By:	Patterson,Rodney	QA Reviewer